



Manufacture and Process Control of TAPPI Size Estimation Charts

Revised 09/10/20

The Size Estimation Charts are manufactured by Printing United Alliance^{*} from an original negative on negative working contact film. The film positive is produced in a NuArc contacting frame with a NuArc light source and built-in light integrator which control the exposure. Each piece of photographic film that is produced during the manufacturing process is evaluated with an X-Rite transmission densitometer for correct exposure by measuring D-Max and dot gain in a 50% screen tint.

****Measurement/Calibration of Dot Sizes**

The .20 dot on each piece of photographic film is measured with a Micro Vu Vertex (model number-311UC, SN-0311UC01508) measurement system. Calibration of the Micro Vu Vertex is performed by HUM Precision Inc. ISO/IEC 17025, AZLA Cal Lab Certificate #1579.01., standard calibration date-09/30/2022 HUM Precision Inc. meets the requirements of ISO/IEC 17025:2005, ANSI/NCSL Z540-1-1994 & MIL Std. 45662A.

Measurement of Dots

The Size Charts are exposed with the same master film negative, insuring repeatability of the image. The 0.20 dot on each chart (photographic contact film) is measured with the Micro Vu Vertex. This is an exacting photographic process, if the 0.20 dot is within specifications, the other dots on chart will be correct having evaluated each piece of film for correct exposure with the X-Rite transmission densitometer during manufacturing.

- ❖ The dots on the chart are correct within an average 10% or 0.005 square millimeters, whichever is the larger.
- ❖ The rectangles are provided for approximate visual comparison and are not measured.

Specification

This chart should be used in conjunction with TAPPI T 564.

Inspection, Length of Use, and Storage

The chart is made from photographic film; the dots are photographic emulsion that can be damaged if abraded. The chart should be visually inspected for physical damage to the measurement dots before each use. The chart should be replaced every 2 years of use. Recommend environmental conditions for the storage and use of the chart: relative humidity 50% +/-10%, temperature 75 degrees +/- 5 degrees F. The film can change size very slightly under extreme temperature and relative humidity conditions. The recommend environmental conditions for the storage are guidelines; the film is dimensionally stable in normal working environments. The charts should be stored in a dustproof package.

Printing United Alliance assumes limited liability and is only responsible for the replacement of the product to the customer. For additional information regarding manufacturing, contact Printing United Alliance at 412-259-1788.

This information was provided by PRINTING United Alliance on May 1, 2020.

^{*} As of May 1, 2020 Printing Industries of America (PIA) merged with Specialty Graphics Imaging Association (SGIA). The combined association became PRINTING United Alliance (PUA) headquartered in Fairfax VA.

^{**} As of 8/1/2018 new measurement process with a Micro Vu Vertex system replacing the previous microscope reticle procedure.

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Table of Contents Tappi New Printing Technologies Symposium 1996

1. Understanding the eBook Tappi New Printing Technologies Symposium 1996
 - The Rise of Digital Reading Tappi New Printing Technologies Symposium 1996
 - Advantages of eBooks Over Traditional Books
2. Identifying Tappi New Printing Technologies Symposium 1996
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Tappi New Printing Technologies Symposium 1996
 - User-Friendly Interface
4. Exploring eBook Recommendations from Tappi New Printing Technologies Symposium 1996
 - Personalized Recommendations

- Tappi New Printing Technologies Symposium 1996 User Reviews and Ratings
- Tappi New Printing Technologies Symposium 1996 and Bestseller Lists
- 5. Accessing Tappi New Printing Technologies Symposium 1996 Free and Paid eBooks
 - Tappi New Printing Technologies Symposium 1996 Public Domain eBooks
 - Tappi New Printing Technologies Symposium 1996 eBook Subscription Services
 - Tappi New Printing Technologies Symposium 1996 Budget-Friendly Options
- 6. Navigating Tappi New Printing Technologies Symposium 1996 eBook Formats
 - ePub, PDF, MOBI, and More
 - Tappi New Printing Technologies Symposium 1996 Compatibility with Devices
 - Tappi New Printing Technologies Symposium 1996 Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Tappi New Printing Technologies Symposium 1996
 - Highlighting and Note-Taking Tappi New Printing Technologies Symposium 1996
 - Interactive Elements Tappi New Printing Technologies Symposium 1996
- 8. Staying Engaged with Tappi New Printing Technologies Symposium 1996
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Tappi New Printing Technologies Symposium 1996
- 9. Balancing eBooks and Physical Books Tappi New Printing Technologies Symposium 1996
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Tappi New Printing Technologies Symposium 1996
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Tappi New Printing Technologies Symposium 1996
 - Setting Reading Goals Tappi New Printing Technologies Symposium 1996
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Tappi New Printing Technologies Symposium 1996
 - Fact-Checking eBook Content of Tappi New Printing Technologies Symposium 1996

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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